

Work Order ID 68356

Tuesday, April 12, 2011 10:10:34 AM



Page 1

Item ID:	D3793-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	4/12/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	4/15/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-04-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3793	Rev A								

100		0.00							
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	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3793								
304 . 210	Dwg Rev: <u>A</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
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QC	Memo	0.00							
Quality Control									

B11-4-19

(13)

B11-4-19

W 11 04 19 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

[illegible]**Setup Start**

[REDACTED]

Stop

[illegible][illegible]**Cust Item ID:**

Customer:

Reference:

Run Start

(b) (7)(C), (b) (7)(D)

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Abstract

**Insp.
Stamp**

0,00

Abstract

NC BRAKE

0.00

Brake NC

Memo

Brake NC

1-Deburr if necessary
2-Form on Brake as per Dwg D3793 using Jigs

SB 11/04/19

13

0.00

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

8/10/20

413

0.00

...the ...

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

Powder Coating

START TIME: 10:00
OVEN TEMPERATURE: 300°
FINISH TIME: 10:30

13 BR 11-4-21.

W/O:		WORK ORDER CHANGES					
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Tuesday, April 12, 2011 10:10:34 AM

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 0 ME 11/04/21

170

Identify as per dwg & Stock Location: FR-18 0.00

Packaging

Memo

0.00

Packaging

13 BL 11-4-21

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/4/21 ME

ME

11-04-21

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Picklist Print

Tuesday, April 12, 2011 10:10:40 AM

Page 1

Work Order ID: 68356



Parent Item: D3793-3



Parent Item Name: Wearshoe



Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	67.4000	1.2828	16.20379	17.		
												1811-4-18	

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

67.4

116437

25.4

116623

42

116437

(13)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	818356
Description: Wearshoe		Part Number:	D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.192	✓		V KB02	
0.300 x 0.300	+/-0.010	303 x 305	✗		V	
1.885	+/-0.010	1.889	✓		V	
4.389	+/-0.010	4.382	✓		V	
6.547	+/-0.010	6.536	✗		V	
6.00	+/-0.030	6.00	✓		T KB01	
6.75	+/-0.030	6.75	✓		T	
2.000	+/-0.010	2.00	✗		V	
4.750	+/-0.010	4.750	✓		T	
9.500	+/-0.010	9.500	✓		T	
14.250	+/-0.010	14.25	✓		T	
17.750	+/-0.010	17.750	✓		T	
26.735	+/-0.010	26.735	✓		T	
Ø0.531 x 0.780	+0.008/-0.001	531 x 784	✓		V	

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-4-19	Date: 11.04.19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD [Signature]	[Signature]

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

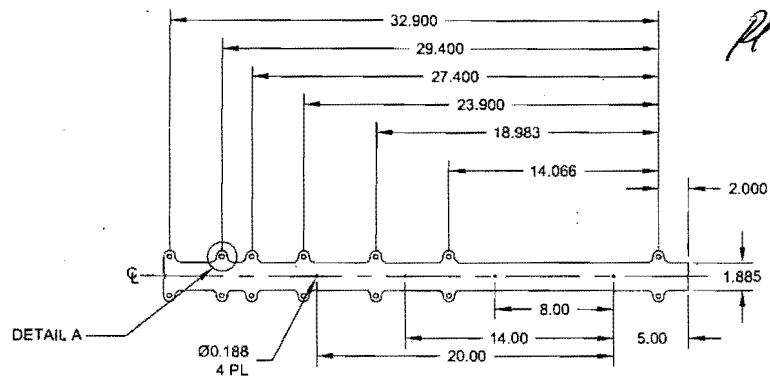
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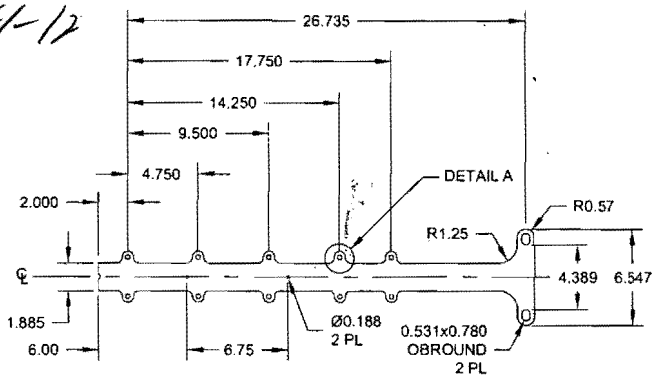
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 08354

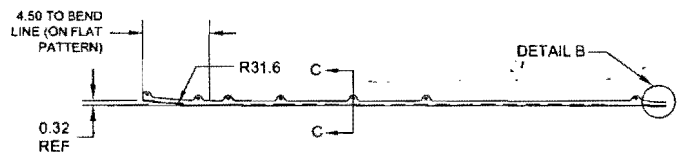
2111-04-12



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08-05-23/18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3793	SHEET 1 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	WEARSHOE	NTS
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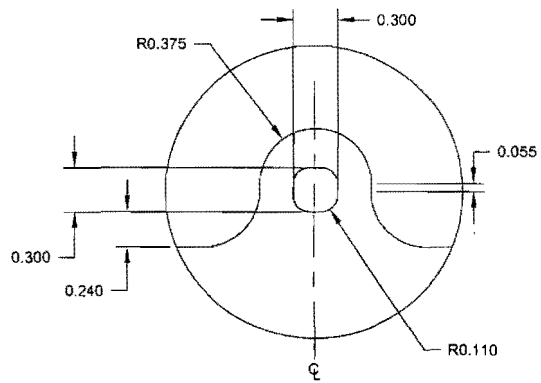
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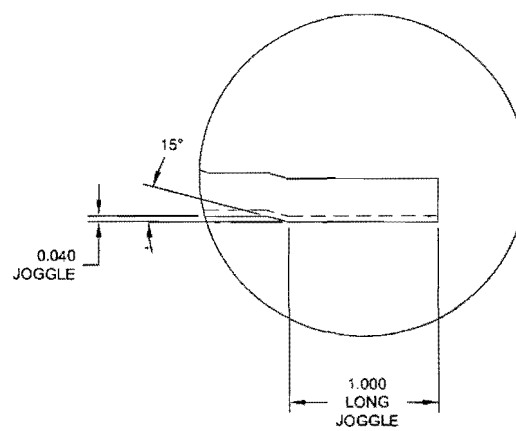
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8 7 6 5 4 3 2 1

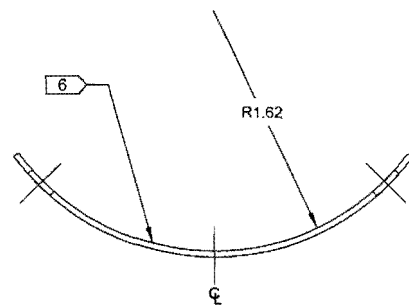
ULO 68354



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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8 7 6 5 4 3 2 1

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